Work Order September 29, 200												Page 1
Revision ID:	D2648-3 D Wearpad			Accept				S	Setup	Start Stop		
Start Date: 2 Required Date: 0 Reference:	29/09/2009 06/10/2009	Start Oty: 20.0 Req'u Qty: 20.0	1 (88)(8 (81) 88)(1		Cust Item I Customer:	D:					1 18811106 : 81	
	Process Pla	in: <u>fl</u>	Date <i>09-9-29</i> Date:	Tooling: SPC (Y/N):		ate:		1		Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr							_			Pk
D2648	Rev	D		0.00		W	tou r	pulli	:0_			100
100 		FLOW WATER JE	Г	0.00						R C	1-10-17	
FLOW CNC Waterje	et	l-Cut a 1***** □	s per Dwg D2648 = *********** ****************** rr if necessary	****CUT WITH FILE D Dwg Rev: D DPi	2648- rog Rev: D							4
110		QC2- Inspect parts	off machine FAI/FAIB	0.00								
QC Quality Control		Memo		0.00						R	9-10-	ا ا
		QC8- Inspect parts		0.00	orliola		C	control (12/14)	ומ מינו	9		
QC Quality Control		Memo		0.00					502	ah-		
									7C/	who he	i	ė

Dart Aerospace Ltd

W/0: 525/6 WORK ORDE		WORK ORDER CH	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.10.19	120	took alyx1 D2648-3 As template	8	3/10/13	(R)	65-10-30	Salvola

Part No: <u>D2648-3</u>	PAR #: Fault Category:	NCR: Yes No DQA:	_ Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORD	ER NON-CONFORMANC	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Anneoval	Anneoval
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
								;
								1

NOTE: Date & initial all entries

September 29, 2009 10:47:58 AM

Item	111
HUCHI	w.

D2648-3

Revision ID:

Wearpad Item Name:

Start Date:

29/09/2009

Start Qty: 20.07

Required Date: 06/10/2009 Req'd Qty: 20.00 Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Tooling: Date:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run

Start Stop



Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation -Description

Date: _____

Draw Number

SB 09/cs/ 19

Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Insp. Number Stamp

Small Fab =

Memo

Deburr if necessary

0.00

0.00

140

Brake NC Brake NC

NC BRAKE

Memo

0.00

0.00

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. □2-

Identify as D2648-3



Large Fab

Large Fab

Memo

0.00

0.00

scription Batch□A/R 560Hardcoat □1-Weld as per Dwg D2648 using Jig DT 8210□2-Remove any Description

weld that penetrated through Wearpadif necessary

Rod # M109060

Work Order ID 52516



Page 3

September 29, 2009 10:47:58 AM

Item ID:

D2648-3

D

Revision ID: Item Name:

Wearpad

Start Date:

29/09/2009

Start Qty: 20.00

Required Date: 06/10/2009 Req'd Qty: 20.00

Accept



Run

Setup Start



Stop



Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Cust Item ID:

Customer:

Date:

Start

Stop

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

OC10- Inspect visual per QSI004- ground welds

Memo

Memo

Memo

Set Up/ **Run Hours**

0.00

Draw Number

Plan Draw Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

170

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

2) Soglul22

180

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

MIDERSCOL

>HP orlot

START TIME: 2.4500 FINISH TIME:

2: 150 BOVEN TEMPERATURE:

Work Order ID 52516



Page 4

September 29, 2009 10:47:58 AM

Item ID:

D2648-3

Revision ID: D

Item Name:

Wearpad

29/09/2009

Start Qty: 20.00

Date:

Accept



Setup Start

Stop



Required Date: 06/10/2009

Reg'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan: _____ Date: ____

Tooling:

SPC (Y/N):

Date: Date:

Run

Start

Stop

Sequence ID/ Work Center ID

190

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

Memo

Set Up/ **Run Hours**

109-10-28.

Draw Number Draw Plan Code Rev.

Accept Qty

Reject Qty

Reject Insp. Number Stamp

200

Packaging Packaging

Identify as per dwg & Stock Location: FP-17

0.00

H 09/10/26

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Picklist Print

September 29, 2009 10:47:57 AM

Work Order ID: 52516

Parent Item:

D2648-3RevD

Parent Item Name:

Wearpad



Start Date: 29/09/2009

Required Date: 06/10/2009

Start Qty: 20.00

Required Qty: 20.00

Component	Item	ID/
Item Name		

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

Last Location

Roufe Seq ID Unit of Measure

Qty on Hand

Qty Remaining Qty To Pick Issued

Date ' Issued

Status

Page 1

M1010S16GA

Comments:

Purchased

No

100

sf

111.6200 1.5789

3.8683

18 9-10-17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

105706

111410

MAT

111.62 0.6 111.02

105706

1010/1025 sheet 16GA

DART AEROSPACE LTD	Work Order: 3250		
Description: Wearpad	Part Number:	D2648-3	
Inspection Dwg: D2648 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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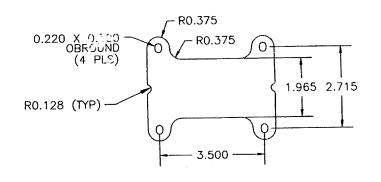
Tolorance	Actual	Accent	Reject	Method of	Comments
Tolerance	Dimension	Accept	Reject	Inspection	001111101110
+/-0.010	1.969	9			
+/-0.010	,	×			
+/-0.010	3,499	X			
+/-0.010 x +/-0.010	1				
+/-0.010		*			
+/-0.010		>			
	+/-0.010 +/-0.010 x +/-0.010 . +/-0.010 +/-0.010	Tolerance +/-0.010 +/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010	Tolerance Dimension Accept	Tolerance Dimension Accept Reject	Tolerance Dimension Accept Reject Inspection

Measured by:	HR.	Audited by: 🤤	Prototype Approval:	N/A
Date:	9-10-17	Date: @ 19	Date:	N/A

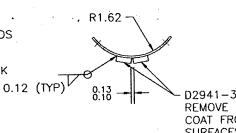
Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM A	
				/ /

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO.

D2648-1 FLAT PATTERN



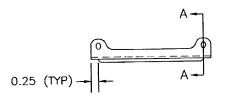
R1.62 7560 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK 0.1



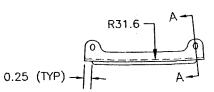
SECTION B-B

- D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

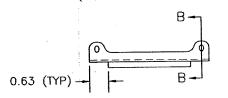
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







99.11.17	ADDED D26487
97.06.26	R31.6 WAS R19.6
97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
97.03.25	NEW ISSUE
DRAWN BY	DART DART AEROSPACE USA, INC.
APPROVED	DRAWING NO. REV. D
#	D2648 SHEET 1 OF 1
	TITLE SCALE
	WEARPAD 1:2
	97.06.26 97.05.30 97.03.25 DRAWN BY

BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES